

Date: Wednesday, 21/05/2008 2:04:51 PM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: GUIDE ASSEMBLY		
Job Number	: 39375			Part Number	: D3572041		
Estimate Number	: 12709			Drawing Number	: D3572 REV.C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 21/05/2008	S.O. No.	:	Drawing Revision	:		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 28/05/2008 Qty: 4 Um: Each		
Previous Run	: 38300						
Written By	:						
Checked & Approved By	: <u>MF</u>						
Comment	: Est Rev:A New Issue 07-02-07 JLM est rev B revB dwg EC Est Rev:C Removed D3572-7 Cap 07-06-11 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D35723	Guide	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) GUIDE Batch: <u>339313</u>	
2.0	D35725	Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) BRACKET Batch: <u>332415</u>	
3.0	M6061T6T1000W188	6061T6 TUBE 1.00 X .188W	
		Comment: Qty.: 2.3405 f(s)/Unit Total : 9.3618 f(s) 6061-T6 Round Tube 1.00"x 0.188 wall Batch: <u>M104480</u>	
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 1-Cut Tube D3572-1 as per Dwg D3572 2-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572 A/R AL ROD Batch: <u>M106834</u>	

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Part Number: D3572041

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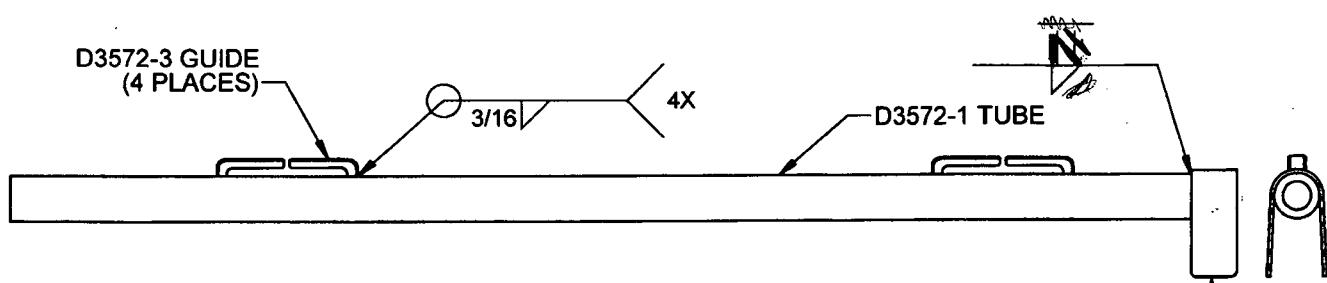
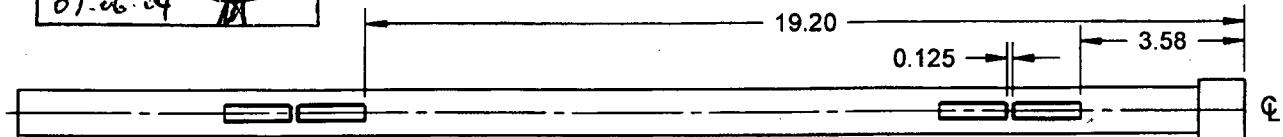


30 min  
28/05/2008  
S.284 08.11  
#1 315.0 F  
#2 D3572041 F  
#3 D39375 F  
#4 D39375 F

Seq. #:	Machine Or Operation:	Description :
5.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
6.0	QC9 /QC125	VISUAL WELDING INSPECTION
		QC125 08/05/27 X8
		QC125 08/05/27 (4)
		Comment: VISUAL WELDING INSPECTION
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		4X
		Comment: HAND FINISHING RESOURCE #1
		Chemical Conversion Coat as per QSI 005 4.1
8.0	POWDER COATING	POWDER COATING
		m/05642
		(4)
		Comment: POWDER COATING
		Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		HL
		08.05.28
		(4)
		Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
10.0	PACKAGING 1	PACKAGING RESOURCE #1
		JS 08/05/28 (4)
		Comment: PACKAGING RESOURCE #1
		Identify and Stock
		Location: ST247
11.0	QC21	FINAL INSPECTION/W/O RELEASE
		08/05/28 J
		Comment: FINAL INSPECTION/W/O RELEASE
	Job Completion	
		U 08.05.28

**DART**

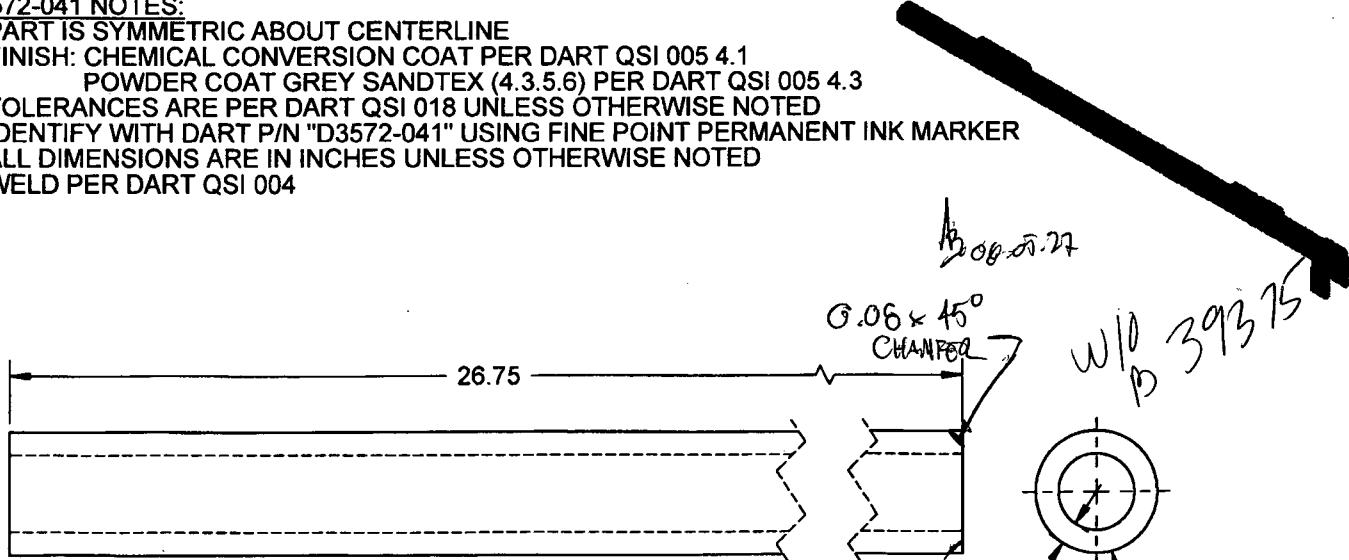
DESIGN <i>LG</i>	DRAWN BY <i>CE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JB</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3572</b>
DATE 07.06.01		REV. C SHEET 1 OF 2 TITLE <b>GUIDE ASSEMBLY</b> SCALE 1:4

**RELEASED**07.06.01 *#*

### D3572-041 GUIDE ASSEMBLY

#### D3572-041 NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004



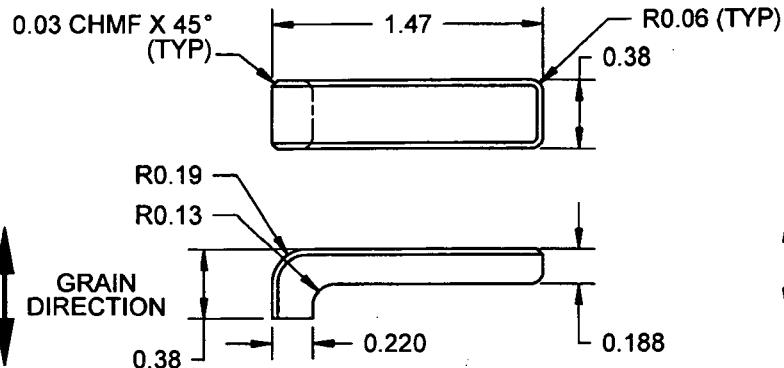
### D3572-1 TUBE

#### D3572-1 NOTES:

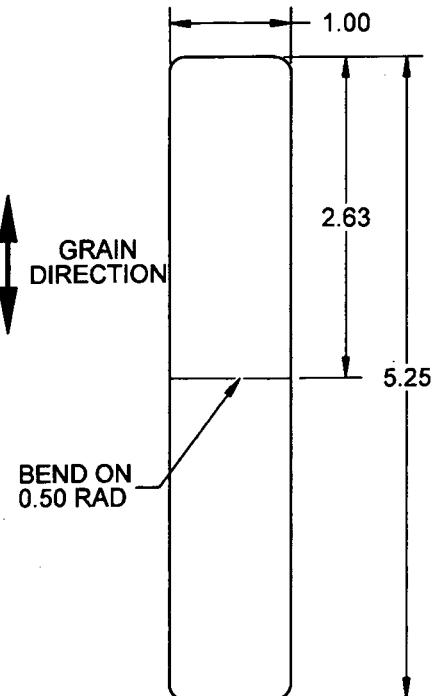
- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

**DART**

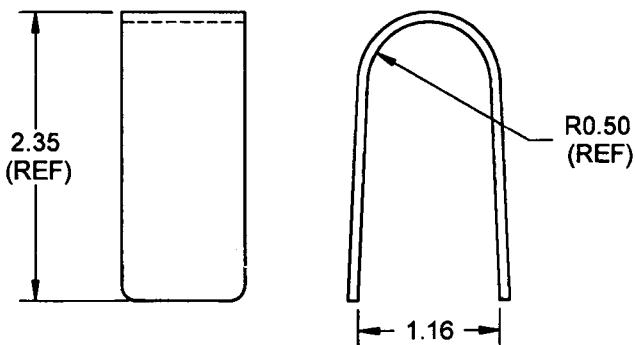
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>SH</i>	DRAWING NO. <b>D3572</b>	REV. C SHEET 2 OF 2
DATE 07.06.01	TITLE <b>GUIDE ASSEMBLY</b>	SCALE 2:3	



1 **D3572-3 GUIDE**



2 **D3572-5 FLAT PATTERN**



**D3572-5 BRACKET**  
(MAKE FROM D3572-5F)

**RELEASED**

07.06.01 *SH*

**D3572-3/-5 NOTES:**

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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